



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9366	REV. A SHEET 1 OF 2
DATE 07.02.07		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS
A	07.02.07	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 Rev. 2
REF. CANADIAN STC: SH01-5
REF. FAA STC: SR01304NY

For D407-667-205 Aft Crosstubes at CHG 004 or later, the D2856-600-851 Abrasion Strip has been removed, the center D2894-1 Support has been bonded onto the crosstubes using Magnobond 6398 and D3595-075-430 Rubber Cushions have been installed underneath the MS21920-24/-25 Clamps. Amend Parts List of IIN-D206-667 Section 5 and ICA-D206-667 Section 32.8 as follows:

Remove:

Item	QTY -205	Part Number	Description
15	2	D2856-600-851	ABRASION STRIP
18	2	MS21920-24	CLAMP

Add:

Item	QTY -205	Part Number	Description
18	2	MS21920-25	CLAMP (OR MS21920-24)
50	2	D3595-075-430	RUBBER CUSHION

To prevent the center support from shifting on D407-667-205 Crosstubes at CHG 003 or earlier, the D2894-1 Support should be removed and re-installed as follows:

Note: The MS21920-24/-25 clamps are interchangeable to accommodate varying diameters.
Ensure there is a minimum of 1.5 threads in safety on the nuts.

- Follow section 32.1 of ICA-D206-667 for the removal of the crosstubes from the helicopter.
- Remove the qty(2) MS21920-24 Clamps from the crosstube that fasten the D2894-1 Supports to the crosstube.
- Remove the D2856-600-851 Abrasion Strip from the crosstube per section 32.5 of ICA-D206-667.
- Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection. Touch up finish per item 5.3.9 of 300 hour inspection.
- Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2894-1 Support and re-install the Support on the crosstube as shown in Figure 1. Use rocker beam assembly to properly align the D2894-1 Support. Ensure the Rocker Beam Assembly can move freely without any friction with other parts. Position and secure the D2894-1 Support on the crosstube using MS21920-24/-25 Clamps. Install a D3595-075-430 Rubber Cushion underneath each MS21920-24/-25 Clamp. Torque clamps 80-100 in-lb. Let the D407-667-205 Crosstube Assembly cure before re-installing the crosstube on the aircraft.
- Re-install the D407-667-205 crosstube per Section 32.2 of ICA-D206-667.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	07.02.07
CERT. NO.:	SH01-5
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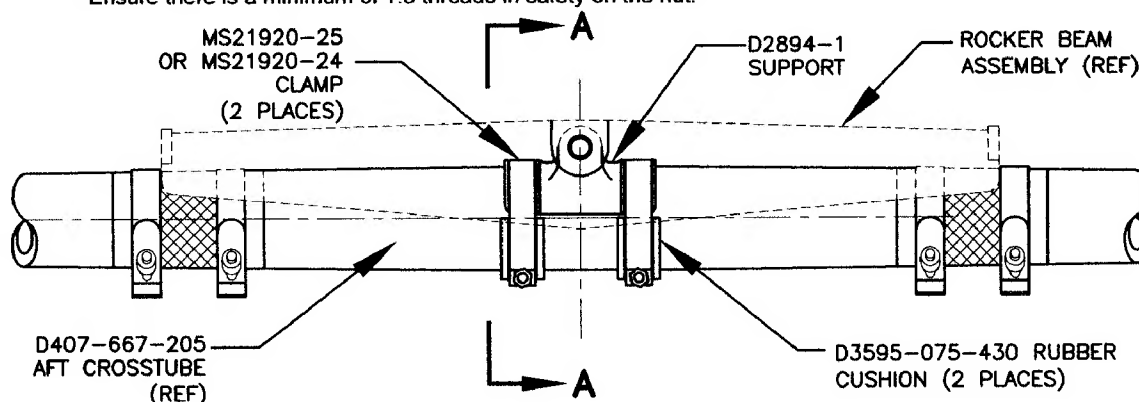
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9366	REV. A SHEET 2 OF 2
DATE 07.02.07		TITLE CROSSTUBE SUPPORT CHANGE	SCALE NTS

For customers who would like to upgrade their D407-667-205 Aft Crosstubes from CHG 003 or earlier to CHG 004, the following kit can be obtained from Dart:

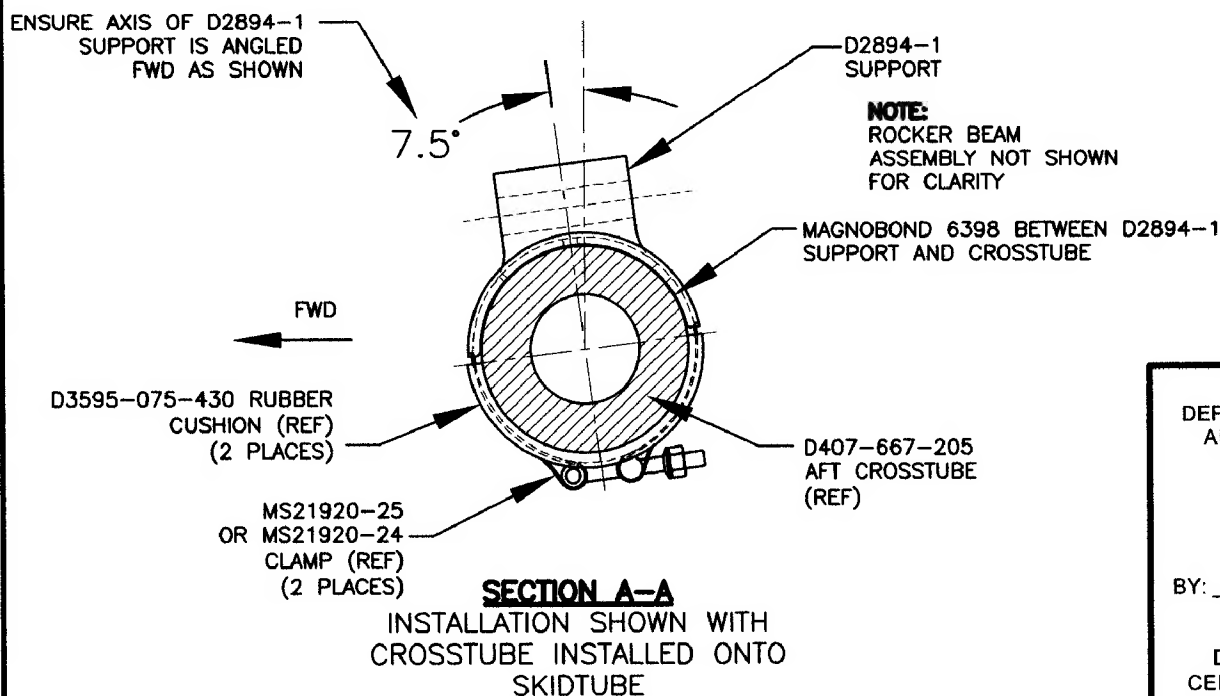
DSI 9366-011 PARTS LIST

QTY -011	Part Number	Description
X	DSI 9366-011	CROSSTUBE SUPPORT CHANGE
2	D3595-075-430	RUBBER CUSHION
2	MS21920-25	CLAMP (OR MS21920-24)

Note: The MS21920-24/-25 clamps are interchangeable to accommodate varying diameters. Ensure there is a minimum of 1.5 threads in safety on the nut.



**FIGURE 1 - CROSSTUBE SUPPORT
INSTALLATION ON D407-667-205**



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

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